

Date:  
User:Monday, 12/01/2009 2:37:35 PM  
Julie Dawson

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 44673 *B*  
 Estimate Number : 13030  
 P.O. Number :  
 This Issue : 12/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 43664  
 Written By :  
 Checked & Approved By : *JD 09.01.13*  
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC  
 Est Rev:B ECN 1113P 08-01-22 DD  
 Est Rev:C ecn1162 08-04-02 DD verified by: EC

Drawing Name : WELDMENT TOP PANEL  
 Part Number : D36505  
 Drawing Number : D3650 REV.C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 02/02/2009 Qty: *2* Um: *3* Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.8537 sf(s)/Unit Total : 3.4146 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: *109398* *B 9-1-21*

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3650

Dwg Rev: *C*Prog Rev: *C**B 9-1-21**(6)*

2-Deburr if necessary

*B 9-1-21*

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

*B 9-1-21*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*S 09/01/21 (46)*

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3650

*S 09/01/21 (46)*



# Process Sheet

Drawing Name: WELDMENT TOP PANEL

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D36505

Job Number: 44673

Job Number:

Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

7.0

D36507

Seal

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

SEAL

batch

35924 x 2 / 43821 x 2

Angle

8.0

D36509

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ANGLE

batch

42097 x 1 / 43823 x 5

9.0

AN6604

WASHER

Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

WASHER

batch

NAS9307M403

10.0

Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

RIVET

batch

MS20427M33

11.0

Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

batch

MS210603K

12.0

Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut Plate

batch



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-5 PAR #: N/A Fault Category: Eng / Design NCR: Yes No DQA: D Date: 09/02/04  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed:   Date:  

NCR: <u>44673-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.01.29	9.0 + 10.0	MS 206153M15 PROVES TO BE TOO HARD TO INSTALL SINCE MATL THICKNESS IS VERY THIN (0.018"). ESTHETICALLY UNACCEPTABLE.	09.01.29	GO BACK TO INSTALLATION OF D3650-7-8.19 + D3650-9 TO D3650-5B PER REV. B	SB	09.02.03	09.01.29	09.02.03
		NCR 09- 	09.02.03 per QSI 042	130452664 MID 9398 D3893-12 B75377 ADDED TO INCREASE THICKNESS. USED NAS9307M44 RIVETS BECAUSE OF INCREASED THICKNESS	SB	09.02.03	09.02.03 per QSI 042	09.02.03
			09.02.03 per QSI 07L	Acceptable to install 0.018" THICK AL51304 SHEET DOUBLER TO INCREASE THICKNESS. MAT'L BIN M109398	SB	09.02.03	09.02.03 per QSI 042	09.02.03

NOTE: Date & initial all entries

Job Number: 44673

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

MS210623K

Nut Plate

Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)  
12

Nut Plate

batch 1110943825 / m10951323

FF 09/01/29

①

14.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3650

FF 09/01/29

②

15.0

QC5

INSPECT WORK TO CURRENT STEP

see p10 →  
Last page.

Comment: INSPECT WORK TO CURRENT STEP

09/02/04 ②

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

D3650-011

B-45448

09/02/04 ②

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/04 ②

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



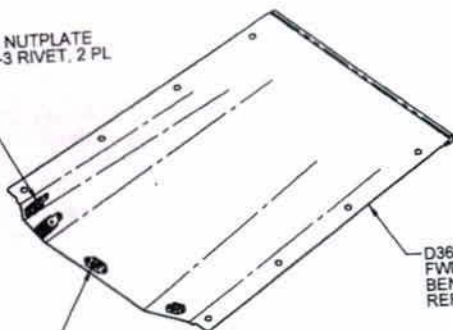
u 09.02.04

1





MS21062-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL



D3650-5B  
FWD PANEL  
BENT PART  
REF

MS21060-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

NAS1149CN432R  
WASHER, REF

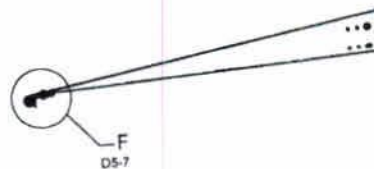
0.74  
0.07

D3650-5B FWD PANEL  
BENT PART  
REF

MS20615-4M5  
RIVET, REF

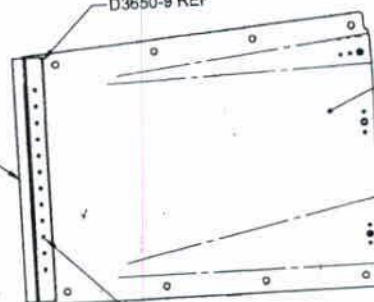
D3650-7-8.19 SEAL  
D3650-9 ANGLE

DETAIL F  
SCALE 3.5X



F  
D5-7

D3650-9 REF  
D3650-7-8.19  
REF



D3650-5B  
FWD PANEL  
BENT PART

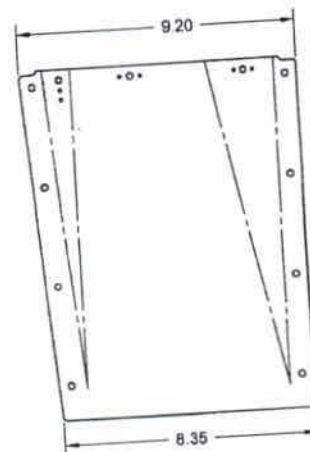
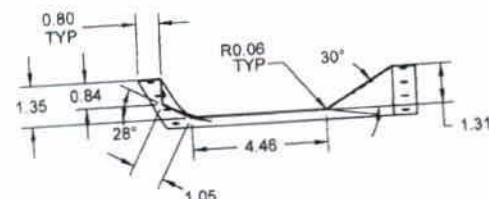
# PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET.  
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.8 lbs

CENTRE D3650-7/9 ON D3650-5B &  
TRANSFER (HOLE) HOLES  
FROM D3650-9 TO D3650-7 & D3650-5B  
AS SHOWN  
INSTALL  
MS20615-4M5 RIVET  
NAS1149CN432R WASHER  
12 PL

D3650-5 FWD PANEL



D3650-5B FWD PANEL BENT PART  
(MAKE FROM D3650-5F FLAT PATTERN)

RELEASE

DESIGN	RF	DART AEROSPACE HAWKESBURY, ONTARIO, CA
DRAWN	RF	
CHECKED		
MFG APPR		
APPROVED		
DE APPR		DRAWING NO. D3650
DATE	08.10.14	TITLE TOP PANEL ASSEMBLY